



Dart Aerospace Ltd.
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D2282-5

Job Sheet 178540



Part No: D2282-5

Job Qty: 50 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 7/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPPRev:B Now on Doosan Lathe 08-06-05 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		7/16/18	0.00	0.00	Start Up Machining		<i>MSP 18/07/04</i>
100	Doosan	50 pcs		7/16/18	0.03	7.77	Doosan		<i>MSP 18/07/04</i>
120	QC	50 pcs		7/16/18	0.00	0.00	QC8		<i>MSP 18/07/04</i>
130	Packaging	50 pcs		7/16/18	0.00	0.00	Packaging3		<i>EL</i>
140	QC21-SA	50 Ea		7/16/18	0.00	0.00	QC21		<i>DAS JUL 11 2018</i>

Part Op 100 - 1-Turn as per Dwg D2282 and Folio FA189
Descriptions: 130 - *****STOCK IN LARGE FAB*****

21
9-00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304RO.750	304 SS Roundbar .750	9.0030 ft (.18006 ea)	90-Start up Operation	<i>S033397</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304RO.750	9	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	2.170Inches ± 0.030	2.200 2.140		
2	Handle Tube	0.063Inches ± 0.010	0.073 0.053	Radius	
3	Handle Tube	0.063Inches ± 0.010	0.073 0.053		
4	Handle Tube	0.125Inches ± 0.010	0.135 0.115		
5	Handle Tube	0.090Inches ± 0.010	0.100 0.080		
6	Handle Tube	45.000Degrees ± 0.000	45.000 45.000	Angle	
7	Handle Tube	0.350Inches + 0.010 - 0.000	0.360 0.350	Radius	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

8	Handle Tube	0.158Inches $\pm$ 0.010	0.158	0.168 0.148	
9	Handle Tube	0.386Inches $\begin{matrix} + 0.005 \\ - 0.000 \end{matrix}$	0.389	0.391 0.386	Diameter
10	Handle Tube	0.700Inches $\pm$ 0.010	0.700	0.710 0.690	Diameter

Plex 6/1/18 12:55 PM Dart.lajeunesse.marie

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Container No: S089005

Part: D2282-5

Job No: 178540

Serial No/Batch: S089005

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/04/18

/ UPDATE

Work Order update only ☐



AGAINST DEPARTMENT/PROCESS

☐	Cross tube	☐	Water Jet	☐	Engineering	☐
☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
☐	Composite	☐	Supplier	☐		☐

Active :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

FAULT CATEGORY

☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence

OTHER :